

Date: Tuesday, 23/12/2008 3:30:34 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CONSOLE ASSEMBLY  
 Job Number : 44316  
 Estimate Number : 11224  
 P.O. Number :  
 This Issue : 23/12/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : // Type : SMALL /MED FAB  
 Previous Run : 43588  
 Part Number : D206547043  
 Drawing Number : D206-547 REV F  
 Project Number : N/A  
 Drawing Revision : F  
 Material :  
 Due Date : 20/01/2009 Qty: 4 Each

Written By :  
 Checked & Approved By : CMF 08-12-24  
 Comment : Est Rev:l 06-01-05 Removed Packing Kit JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2024 Console Extrusion



Comment: Qty.: 3.5910 Each(s)/Unit Total : 14.3640 Each(s)  
 D2024 Extrusion  
 Batch M01

FF 09-08-08

(4)

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, DT 8264-2, DT8264-3, DT8264-4

2-Deburr

FF 09-01-09

(4)

3.0 D26021 Console Side, 206 Console



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description  
 1 D2602-1 Side LH

Batch

B43752

SS 09/01/07

(x4)

4.0 D26022 Console Side, 206 Console



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description  
 1 D2602-2 Side RH

Batch

B43752 x3

SS 09/01/07 x4

SS 09/01/06

(x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 23/12/2008 3:30:35 PM  
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Drawing Name: CONSOLE ASSEMBLY

Job Number: 44316

Part Number: D206547043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2606

Console Bracket, 206/407 Console



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2606

Bracket

38590

SS 09/01/06 (x4)

6.0

D2607

Bracket, 206 Console



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2607

Bracket

32820

SS 09/01/06 (x4)

7.0

MS20470AD33

Rivet, Universal Head



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 MS20470AD3-3

Rivet

M16941

SS 09/01/05 (x4)

8.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 20.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS20470AD3-4

Rivet

M15541

SS 09/01/05 (x4)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Grind weld relief chamfer as per Dwg D206-547

2-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

SS 09-01-09 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: CONSOLE ASSEMBLY

Job Number: 44316

Part Number: D206547043

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/09

X4-1  
X4-2

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Tack weld as per Dwg D206-547

A/R AL ROD Batch: 11104855

FF 09/01/15

M-1 09/01/14

SP 09.01.14

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/01/15

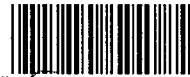
X4-LH

X4-RH

13.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 02/01/15

X4-LH

X4-RH

14.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3

FF 09/01/21

41

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/22

X4

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:20  
320°F  
12:50

M-1 09/01/23

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SS 09/01/23

X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 23/12/2008 3:30:35 PM  
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Drawing Name: CONSOLE ASSEMBLY

Job Number: 44316

Part Number: D206547043

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST156

SS 09/01/23 AY

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26 A

Job Completion



MF 09-01-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



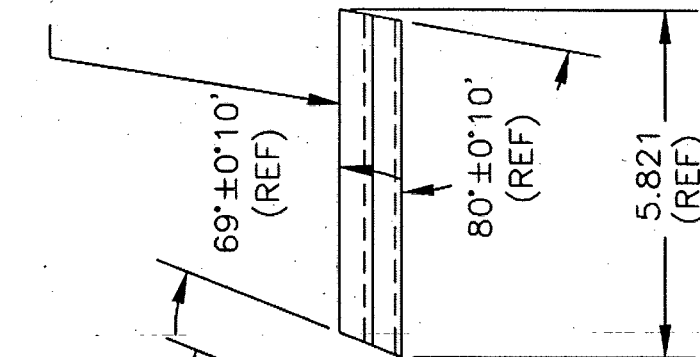


DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D2710	REV. B SHEET 1 OF 1
DATE 99.02.11	TITLE CONSOLE SIDE RAIL		SCALE 1:3
A	97.10.25	NEW ISSUE	
B	99.02.11	DELETE WELD, ADD TEMPL. (TSR A1020)	

RELEASED  
99.03.05 KE



D2710-3 SHOWN  
D2710-4 OPPOSITE



D2710-1 SHOWN  
D2710-2 OPPOSITE

69'±0'10' (REF)  
14.703 (REF)

22'±0'10' (REF)  
77'±0'10' (REF)

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44316

MATERIAL: MAKE FROM D2024 EXTRUSION  
MAKE PER TEMPLATE # DT8264  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <b>BW</b>	DRAWN BY <b>RF</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>CP</b>	APPROVED <b>KE</b>	DRAWING NO. D206-547	REV. F SHEET 1 OF 5
DATE 99.02.11		TITLE CONSOLE ASSEMBLY	SCALE NTS
-	82.11.23	NEW ISSUE	
A	83.01.18	REDRAWN, ADD NOTE 4	
B	84.10.23	D206-547 WAS 01.B.81.017	
C	89.03.30	REDRAWN	
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85	
E	97.10.22	REDRAWN, ADD -043,-045,-047	
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL	

RELEASED  
99.03.05 RE

-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				D206-547-041	CONSOLE ASSEMBLY
	X			D206-547-043	CONSOLE ASSEMBLY
		X		D407-547-045	CONSOLE ASSEMBLY
			X	D407-547-047	CONSOLE ASSEMBLY
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
	1			D2602-1	CONSOLE SIDE
	1			D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
	1		1	D2710-1	CONSOLE SIDE RAIL
	1		1	D2710-2	CONSOLE SIDE RAIL
	1		1	D2710-3	CONSOLE SIDE RAIL
	1		1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET

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WITHOUT NOTICE  
WORK ORDER  
NO. 44316

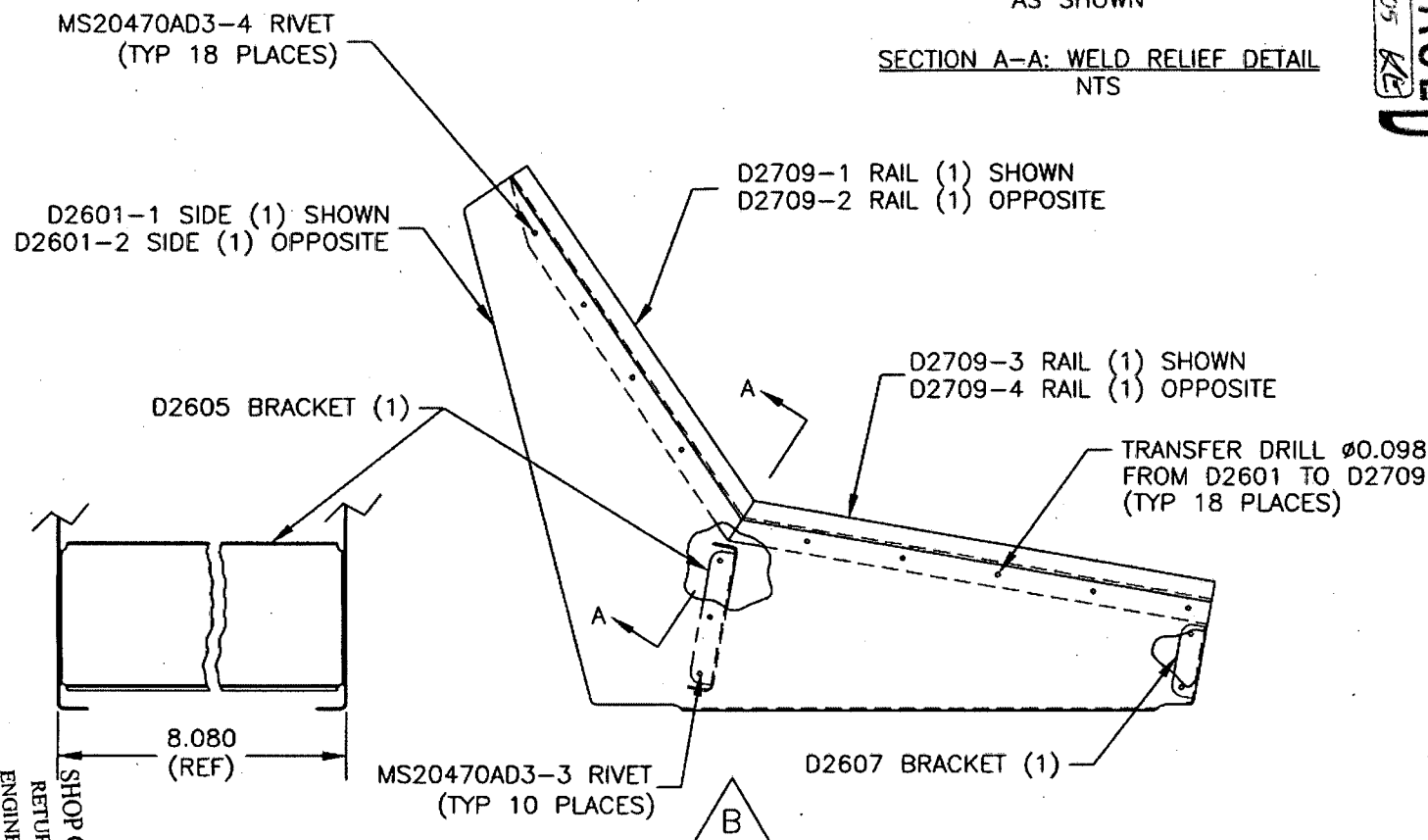
**DART**

RELEASED  
01.07.05 KE



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D206-547-041 (206 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	JP	APPROVED	KE	
DATE	99.02.11	TITLE	D206-547	REV. F
		CONSOLE ASSEMBLY		SHEET 2 OF 5
				SCALE 1:4

**DART**

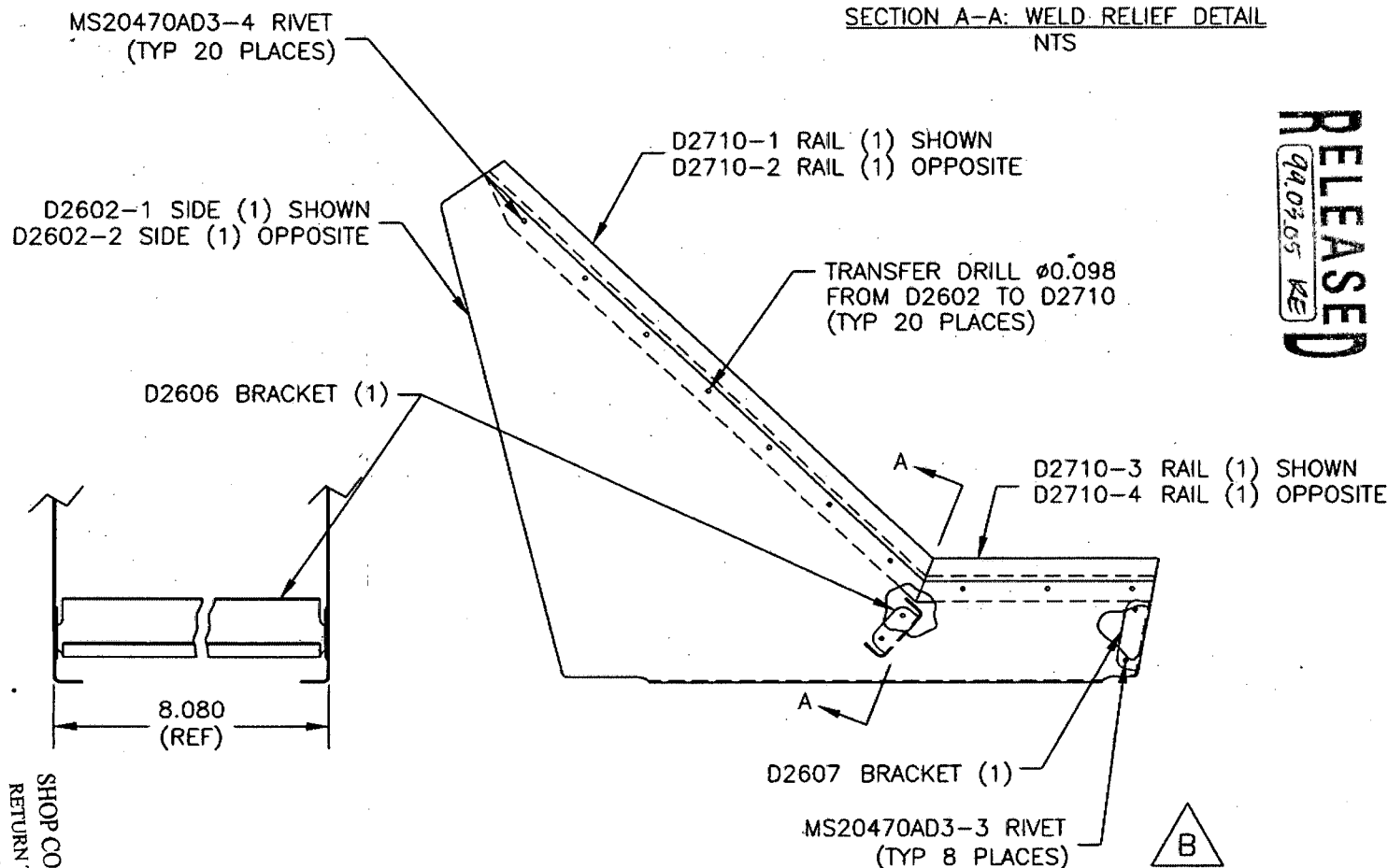
RELEASED  
99.02.11 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
CP	KE	D206-547
DATE	TITLE	SHEET 3 OF 5
99.02.11	CONSOLE ASSEMBLY	SCALE
		1:4



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright 1982 by DART AEROSPACE LTD

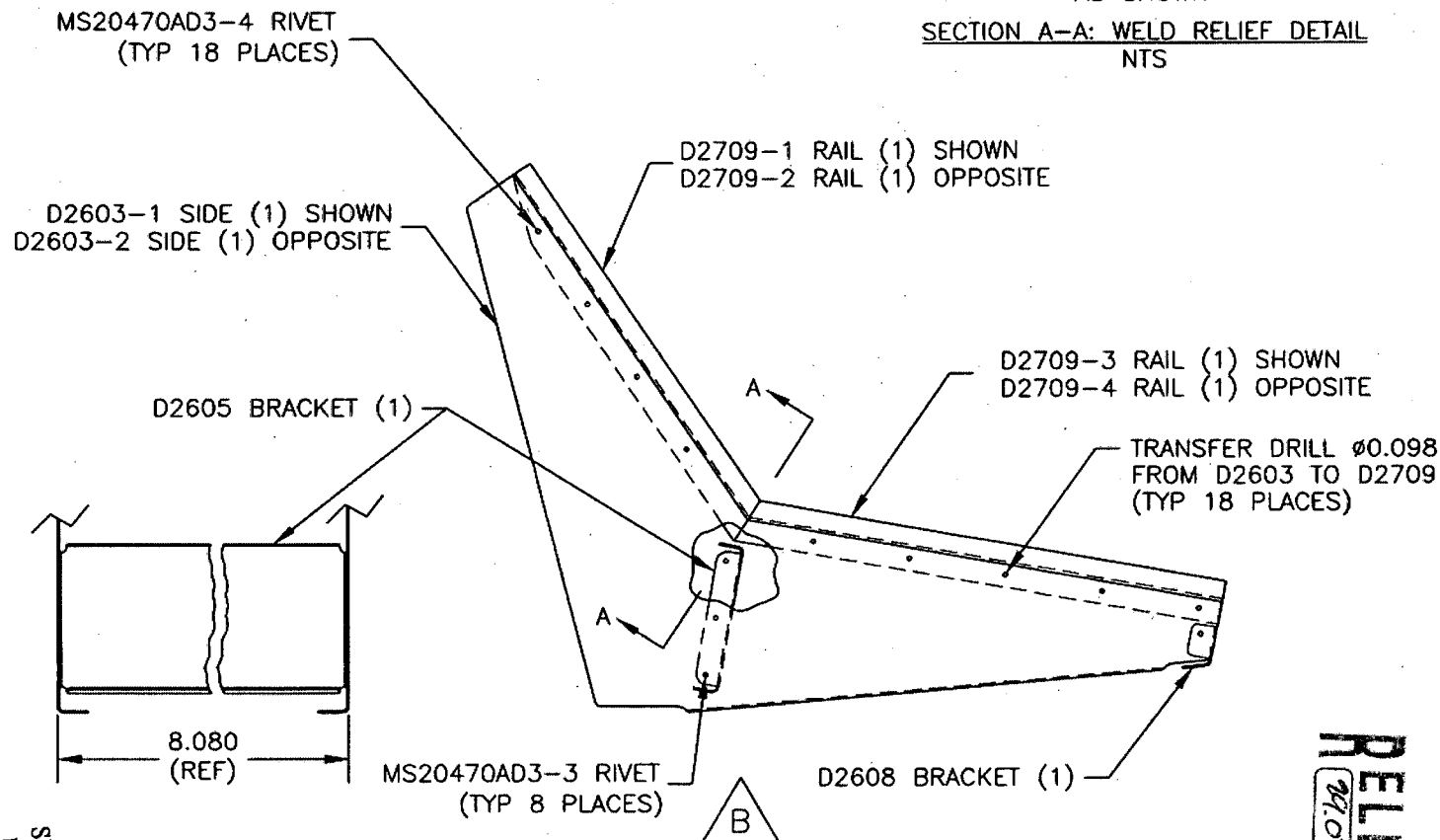
SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44316

**DART**



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D407-547-045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	W	APPROVED	KE	
DATE	99.02.11	TITLE	D206-547	REV. F
			CONSOLE ASSEMBLY	SHEET 4 OF 5
				SCALE 1:4

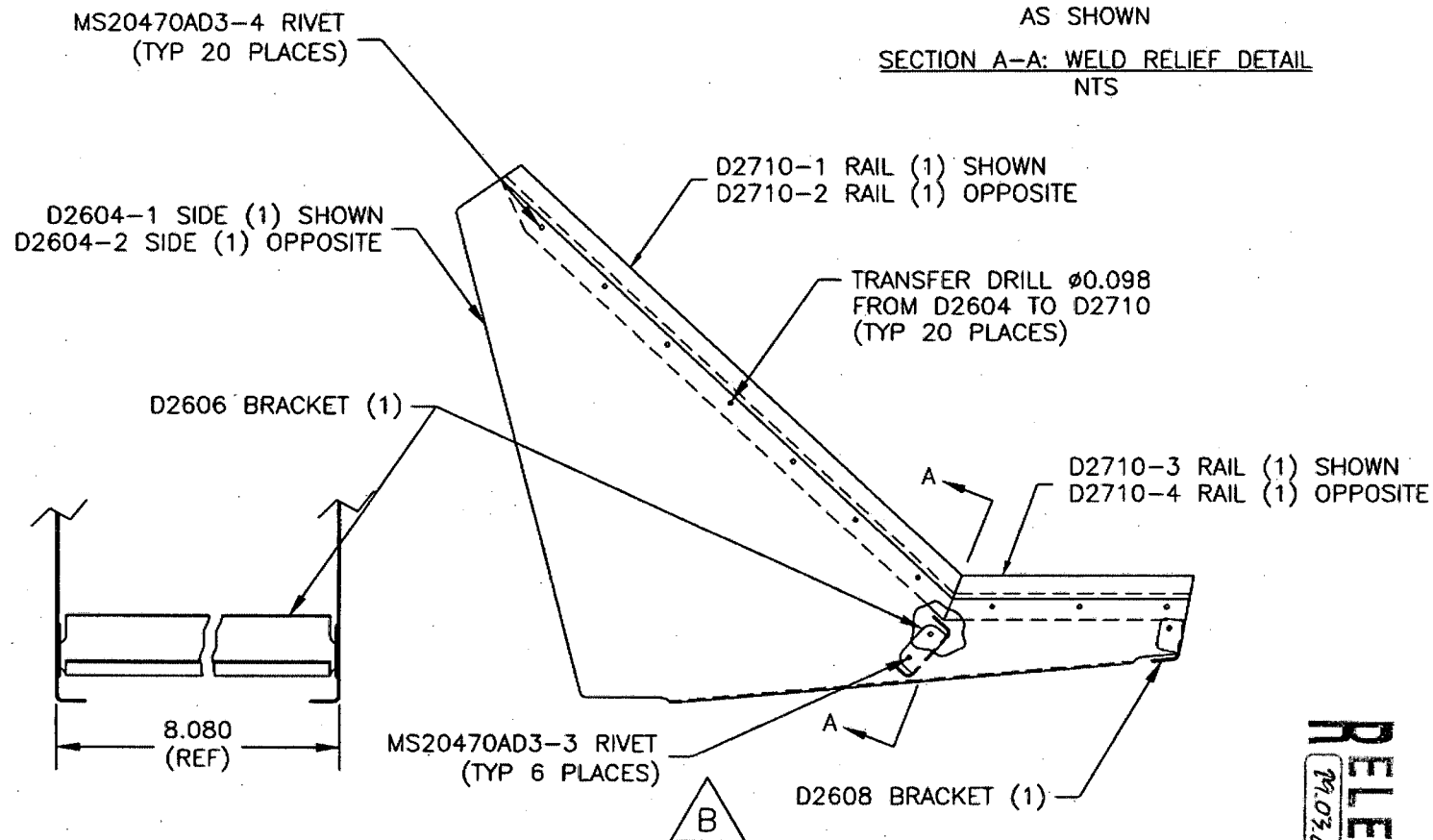
**RELEASED**  
99.03.05 KE

**DART**



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
M0305 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	RF	HANKEBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
CP	KE	D206-547
DATE	TITLE	REV. F
99.02.11	CONSOLE ASSEMBLY	SHEET 5 OF 5
		SCALE
		1:4